

Work Order ID 58950

Thursday, May 20, 2010 10:33:32 AM



Page 1

Item ID: D2989-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 5/26/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: 10-3-20 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2989	Rev D

100 Large Fab 0.00



Large Fab

Large Fab

Memo

0.00

10-08-05

[Signature]

10-08-05

1

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

1.5 ENSURE ONE D3836-041 HAS NO BUSHING and HAS HOLES PER DSI 9473.

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig

****cut cutouts with zip cut as per dwg D3832****

10-07-29

3- remove from jig and weld lable plate as per dwg D2989

A/R ER316 S.S. Rod Batch: *1113328*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Quality Control

Memo

0.00

10-09-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Page 2

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Start Date: 5/26/2010

Start Qty: 1.00

Required Date: 6/10/2010

Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QCS- Inspect part completeness to step on W/O

0.00

all

Memo

0.00

810606

0

130



Powdercoat

Powder Coating

↑ pressure wash
White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

0.00

=> 94 10108109

1

0

Memo

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:15 AM

400°C

8:45 AM

9:00 AM

400°C

9:30 PM

Dart Aerospace Ltd

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

131



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch M115028 0.00

=> H L

10108109

Memo

0.00

Mask lid prior to spray paint black and wing walk as per dwg
A/R Spray paint black batch: M114332

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

141



Packaging

Packaging

Identify as per dwg & Stock Location: C-A 0.00

Memo

0.00

w/o 58054

EP 10/08/09 @

EP 10/08/09 @

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/10 TJ
MK
10-8-10

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Picklist Print

Thursday, May 20, 2010 10:33:37 AM

Page 1

4

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Parent Item Name: Basket Lid Assembly

Comments: IPP Rev: I Removed D2989-043 05-11-03 JLM
 IPP Rev: J 08-08-29 revC as per dwg DD verified by: EC
 IPP Rev: K 08-09-24 plug hole prior to powder coating DD verified by: EC
 IPP Rev: L 08-12-02 revD as per dwg DD verified by:

Start Date: 5/26/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

D2221-1



Rib

Manufactured No 100 Each

23.0000

2

Location

Loc Qty

Loc Code

WA

23

57182

1

57499

10

58122

12

10/08/04

B60172 → ②

D2506



Label Plate

Manufactured No 100 Each

7.0000

1

Location

Loc Qty

Loc Code

WA

7

57599

2

57836

5

10/08/04

B60272 → ①

D2512-7



Rib

Manufactured No 100 Each

8.0000

1

Location

Loc Qty

Loc Code

WA

8

56206

4

58026

4

10/08/04

B59864 → ①

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 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 5/26/2010

Required Date: 6/10/2010


Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 44.0000 2

 Mounting Bracket


Location	Loc Qty	Loc Code
WA	44	
46086	2	
51745	2	
57185	1	
58301	19	
58687	20	

SY 10/08/04
~~B60198~~ → (2)

D2989-13 Manufactured No 100 Each 4.0000 2

 Rib

Location	Loc Qty	Loc Code
WA	4	
57769	4	

SY 10/08/04
 B60576 → (2)

D2989-19 Manufactured No 100 Each 8.0000 2

 Rib

Location	Loc Qty	Loc Code
WA	8	
57770	4	
58085	4	

SY 10/08/04
 B60175 → (2)

Thursday, May 20, 2010 10:33:37 AM

Shop Packet Print

Page 2

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 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 5/26/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

D3832-3



Mesh (Lid)

Manufactured No

100 Each

4.0000

1

Location

Loc Qty

Loc Code

WA

4

57187

1

57833

3

100 Each

9.0000

2

Location

Loc Qty

Loc Code

WA

9

46308

1

53492

2

57626

6

100 Each

4.0000

D3836-041



Rib Assembly (Basket Lid, LH)

Manufactured No

Location

Loc Qty

Loc Code

WA

4

57598

2

58086

2

100 Each

3.0000

1

D3836-042



Rib Assembly (Basket Lid, RH)

Manufactured No

Location

Loc Qty

Loc Code

WA

3

57597

1

58087

2

10/08/04

B59411 → ①

B59903 @ 10/08/04

10/08/04

B60178 → ①

10/08/04

B60179 → ①

Thursday, May 20, 2010 10:33:37 AM

Shop Packet Print

Page 3

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 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 5/26/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

D3852-041



Rib Assembly

Manufactured No

100

Each

4.0000



1

Location

Loc Qty

Loc Code

WA

4

57772

2

58088

2

2

Each

4.0000



1

M 10/08/04

B60180 → ①

D3852-042



Rib Assembly

Manufactured No

100

Each

4.0000



1

Location

Loc Qty

Loc Code

WA

4

57771

2

58089

2

2

Each

4.0000

M 10/08/04

B60181 → ①

Thursday, May 20, 2010 10:33:37 AM

Shop Packet Print

Page 4

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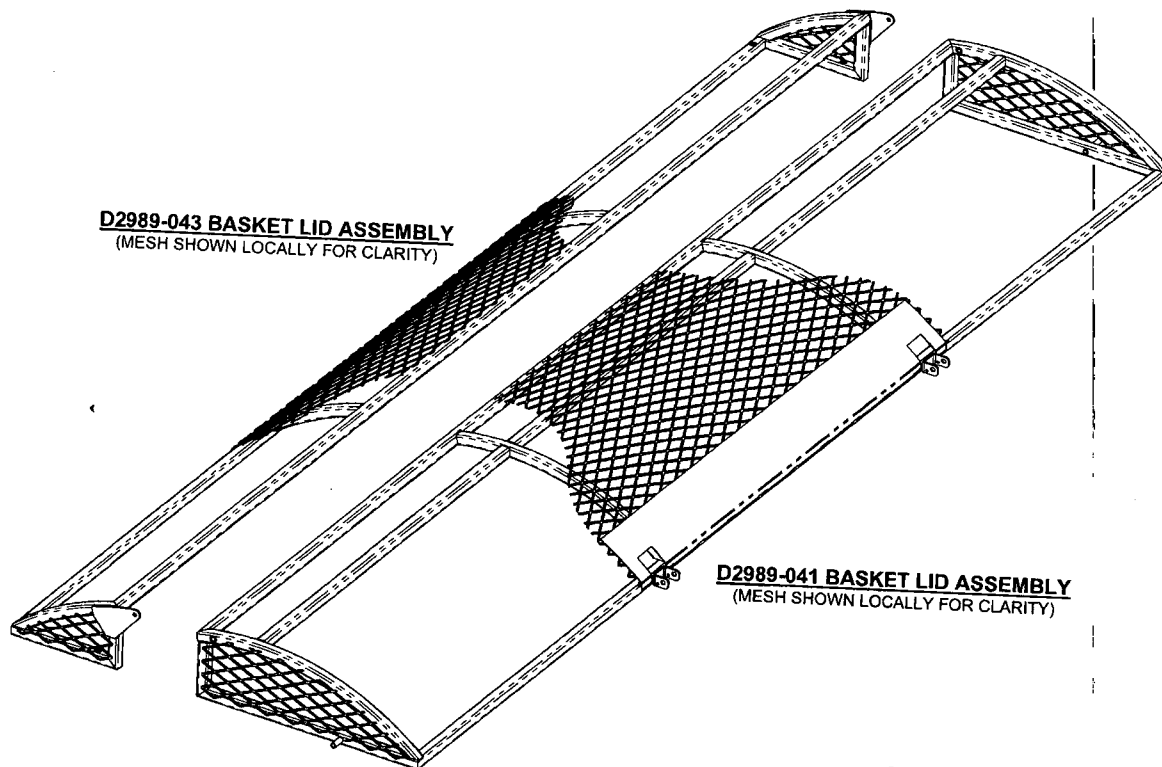
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58950

pl-0-5-20

- NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/12

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1). D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3836-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-11/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2989**
TITLE **BASKET LID ASSEMBLY**
SCALE **NTS**

REV. D
SHEET 1 OF 5

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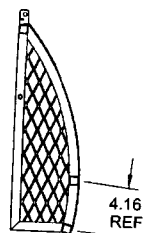
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

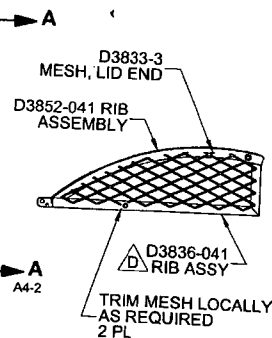
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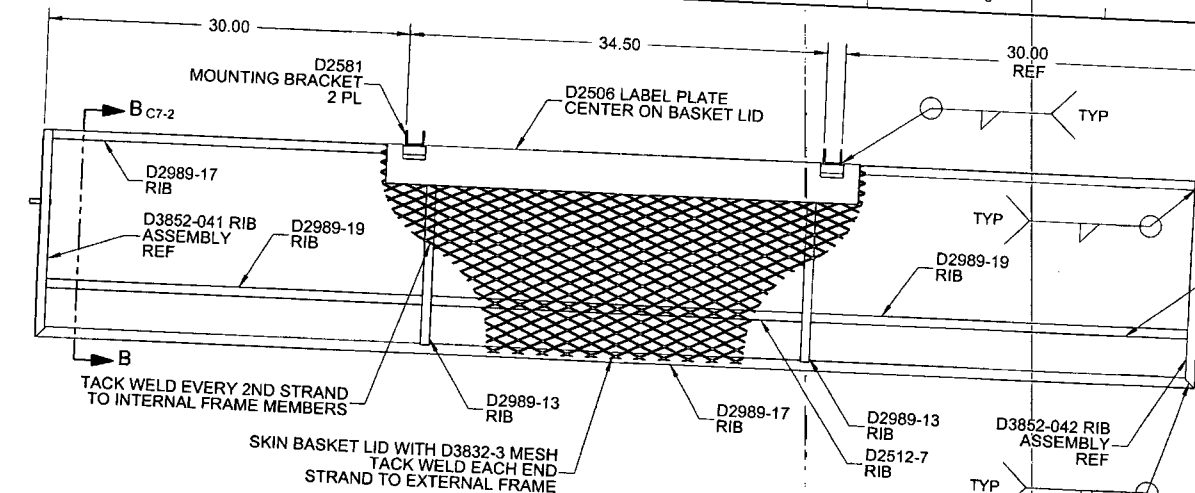
SECTION B-B



4.16
REF



TRIM MESH LOCALLY
AS REQUIRED
2 PL



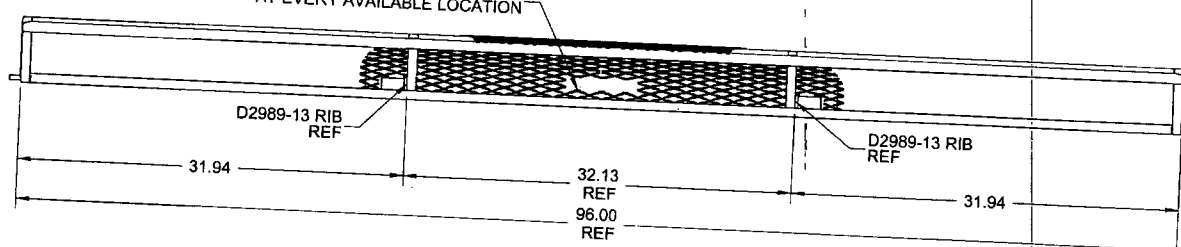
TACK WELD EVERY 2ND STRAND
TO INTERNAL FRAME MEMBERS

SKIN BASKET LID WITH D3832-3 MESH
TACK WELD EACH END
STRAND TO EXTERNAL FRAME

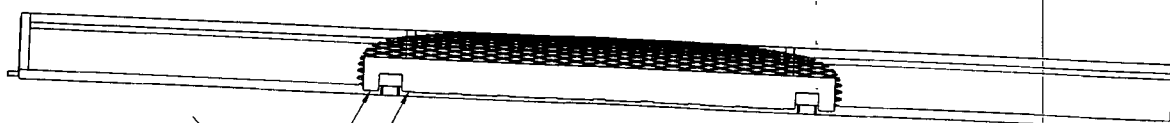
TACK WELD MESH TO LABEL PLATE
AT EVERY AVAILABLE LOCATION

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKID'D

BLACK ANTI-SKID
PAINT THIS SECTION

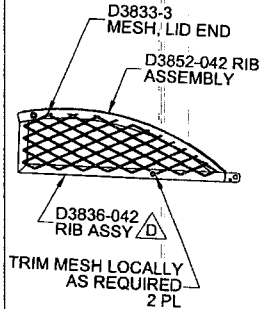


D2989-041 BASKET LID ASSEMBLY (MESH SHOWN LOCALLY FOR CLARITY)



FILL NOTCH
WITH WELD
9 PL

VIEW A:A B8-2



TRIM MESH LOCALLY
AS REQUIRED
2 PL

RELEASED
08/11/18/19

DESIGN	DS
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.09.24

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2989	REV. D SHEET 2 OF 5
TITLE BASKET LID ASSEMBLY	SCALE NTS
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Wb 58930

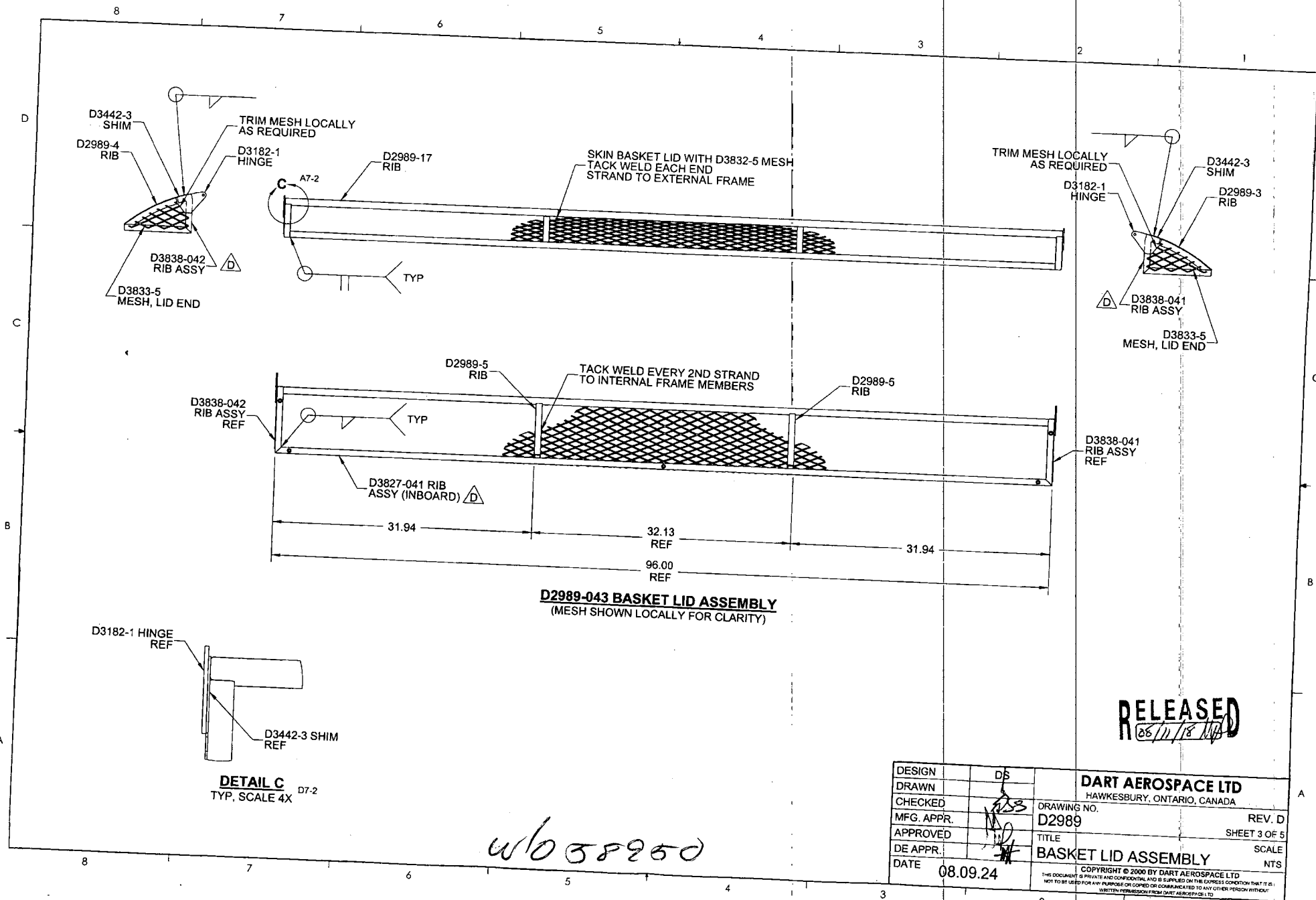
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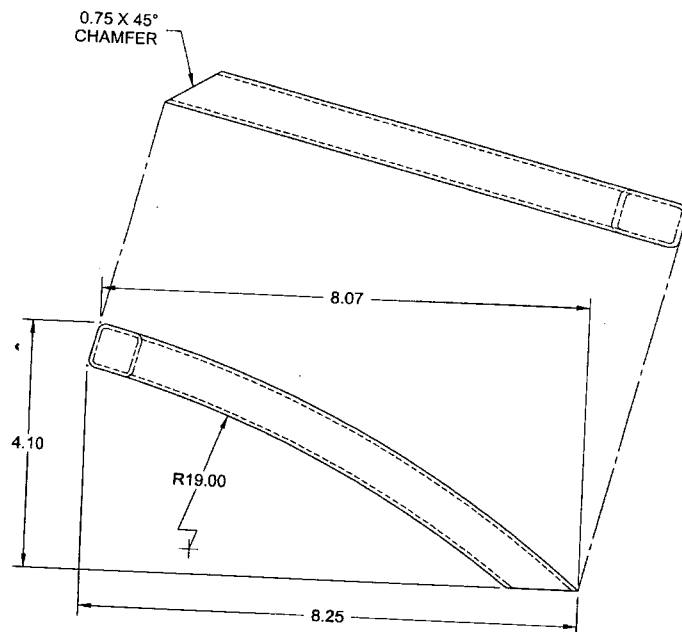
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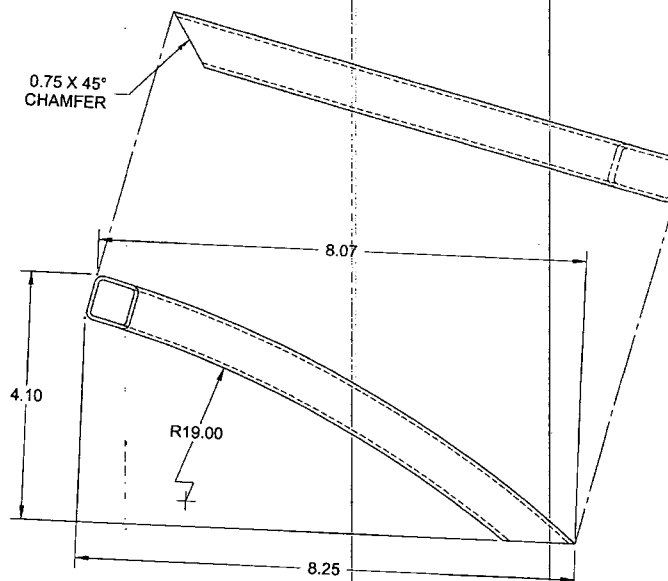
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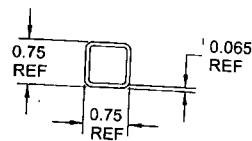


D2989-3 RIB



D2989-4 RIB

also 5895d



TYPICAL SECTION VIEW

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV.
DRAWN			SHEET 4 OF 5
CHECKED		DRAWING NO.	SCALE
MFG. APPR.		D2989	NTS
APPROVED		TITLE	
DE APPR.		BASKET LID ASSEMBLY	
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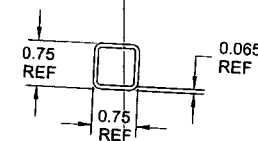
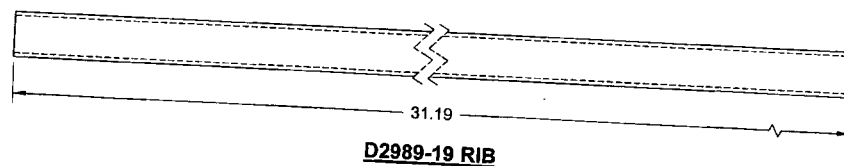
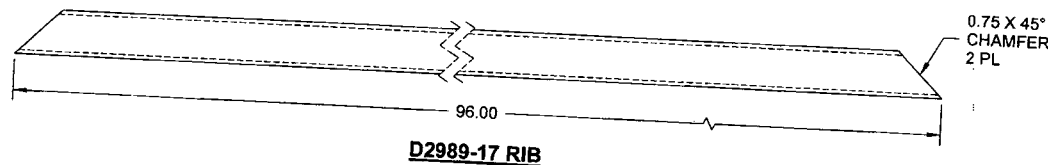
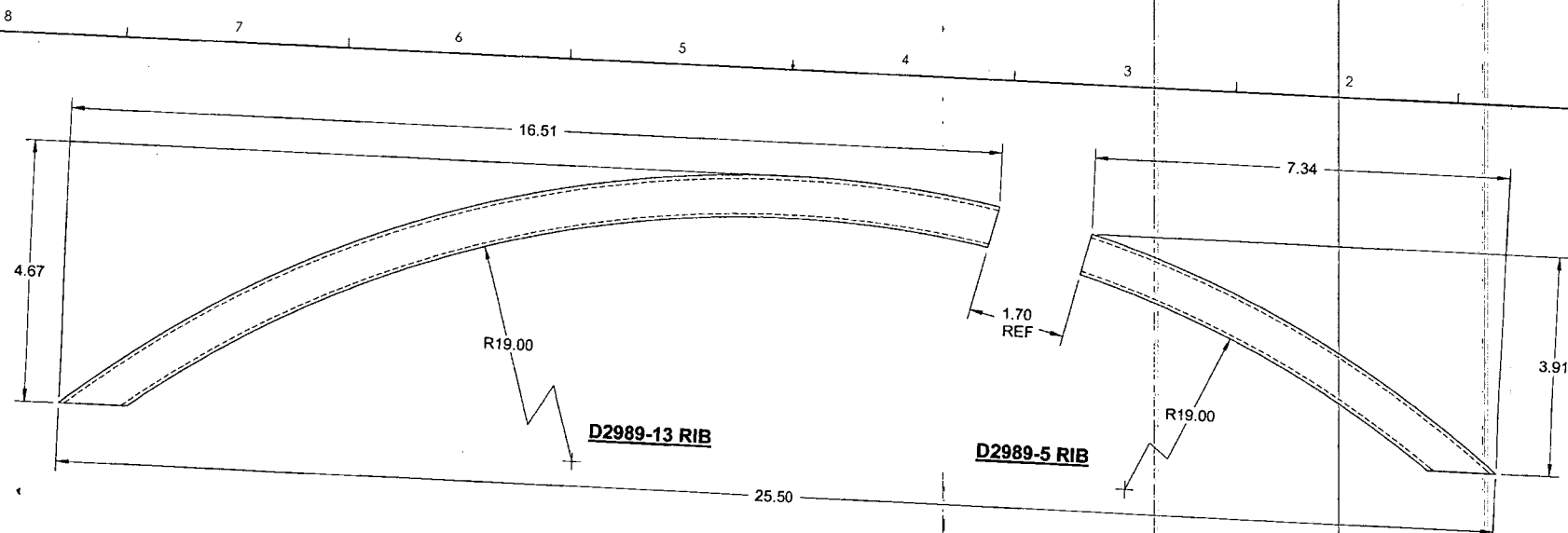
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



TYPICAL SECTION
VIEW

RELEASED
08/11/18

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	REV. D
DRAWN	DS	HAWKESBURY, ONTARIO, CANADA	SHEET 5 OF 5
CHECKED	DS	DRAWING NO. D2989	SCALE NTS
MFG. APPR.	DS	TITLE BASKET LID ASSEMBLY	
APPROVED	DS		
DE APPR.	DS		
DATE	08.09.24		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53405

November 03, 2009 3:46:52 PM

Page 1

Item ID: D2989-041

Revision ID: D

Item Name: Basket Lid Assembly

Start Date: 11/4/2009 Start Qty: 1.00

Required Date: 11/11/2009 Req'd Qty: 1.00

Reference:

Accept
REFERENCE ONLY

Cust Item ID:
Customer:

Approvals: Process Plan: U

QC:

Date:

Tooling:

Date:

Run

Start

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

0.00
09.11.04

* Converted for DS19473 installation

100



Large Fab

Large Fab

Large Fab

Memo

0.00

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

1.5 ensure one D3836-041 has no bushing and has holes per DS19473.

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig

****cut cutouts with zip cut as per dwg D3832****

3- remove from jig and weld lable plate as per dwg D2989

A/R ER316 S.S. Rod Batch: M109213

PD 09.11.05

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

09/11/06

See Eric C

REFERENCE ONLY

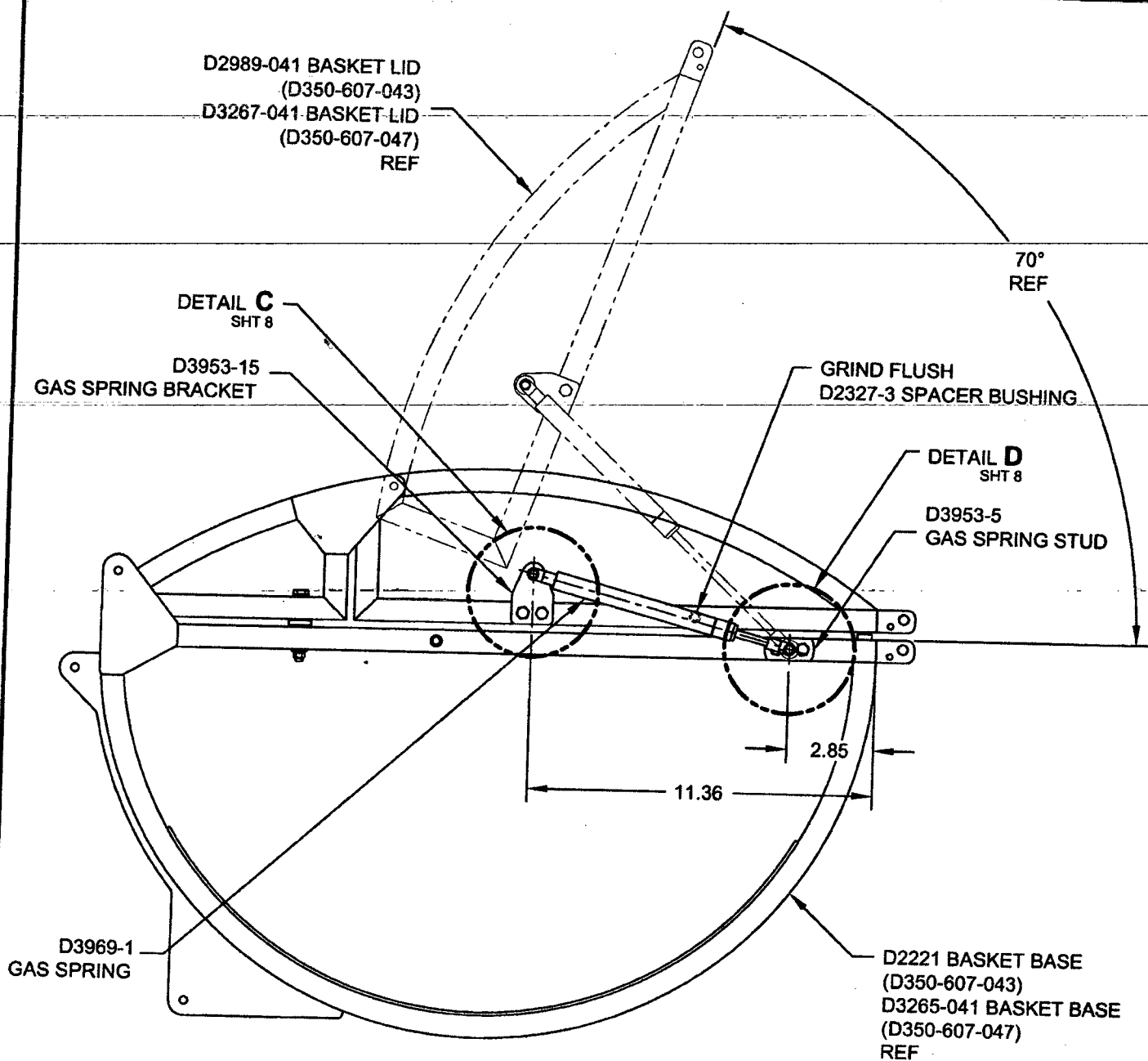


FIGURE 2
D350-607-143 AUTOMATIC LID OPENER INSTALLATION
 (1 END ONLY)

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01




APPROVED

BY: *[Signature]*
 D. SHEPHERD (DE # 02)

DATE: 09.11.11

CERT. NO.: SH94-14

ISSUE NO.: 4

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		AUTOMATIC LID OPENER INSTL	NTS
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